Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
901-873-5300

AC Recondition As Found

PECO FOODS NEWARK
318 SOUTH LOCUST STREET
NEWARK, AR 72562

FolderID: 100336
FormID: 14635557

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	096C
Description:	50HP BALDOR 3600RPM 326TS

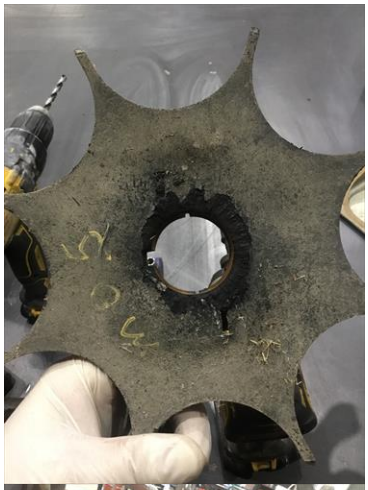
Hi-Speed Job Number:	100336
Manufacturer:	Baldor
Product Number:	M4114T
Spec/ID #:	12J73W559
Serial Number:	096C
HP/kW:	50 (HP)
RPM:	3550 (RPM)
Frame:	326TS
Voltage:	230 / 460
Current:	116/58
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **3 - High** **5 - Good**

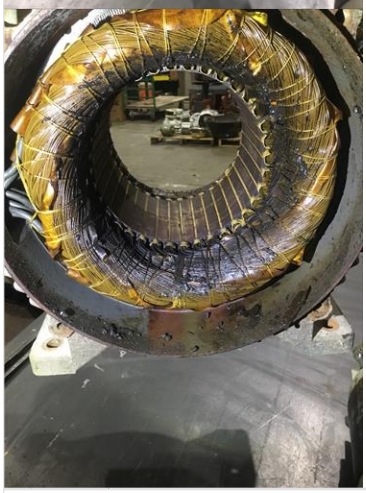
Overall Condition

1. Report Date
2. Nameplate Picture P21

3. Photos of all six sides of the machine. P27








	4.	Describe the Overall Condition of the Equipment as Received *Dirty*		
Initial Mechanical/Electrical				
●	5.	Does Shaft Turn Freely?		**(Yes) Yes**
	6.	Does Shaft Have Visible Damage?		**(No) No**
	7.	Assembled Shaft Runout		
	8.	Assembled Shaft End Play		
	9.	Air Gap Variation <10%		
●	10.	Lead Condition		**(P) Pass**
	11.	Lead Length		**8 Inches**
	12.	Frame Condition		**pass**
●	13.	Fan Condition *Fan is dry rotten*		**(F) Fail**
	14.	Broken or Missing Components		**fan is cracked**
Initial Electrical Inspection				
	15.	Insulation Resistance/Megger		
	16.	Winding Resistance		
		1-2	1-3	2-3
●	17.	Perform Surge Test		**(P) Pass**
	18.	Stator Condition		
	19.	Number of Stator Slots		
Mechanical Inspection				

20.	Drive End Bearing Number-	**6312**
21.	Drive End Bearing Qty.	**1**
22.	Drive End Bearing Type	**(Ball) Ball Bearing**
23.	Drive End Lubrication Type	**(Grease) Grease Lubricated**
24.	Drive End Bearing Insulation or Grounding Device?	**na**
25.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**na**
26.	Drive End Bearing Condition	**excessive wear contamination & metal fatigue**
27.	Opposite Drive End Bearing Number-	**6311**
28.	Opposite Drive End Bearing Qty.	**1**
29.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**
30.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**
31.	Opposite Drive End Bearing Insulation or Grounding Device?	**na**
32.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**wavy washer**
33.	Opposite Drive End Bearing Condition	**excessive wear and contamination**
34.	Drive End Seal	**na**
35.	Opposite Drive End Seal	**na**

Rotor Inspection

36.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**
37.	Growler Test	**(Pass) Pass**
38.	Number of Rotor Bars	
39.	Rotor Condition	**pass**
40.	List the Parts needed for the Repair Below ***6312*** ***6311*** ***Fan***	
41.	Signature of Technician that Disassembled Motor	**Cw**

Mechanical Fits- Rotor

42. Shaft Runout

43. Rotor Runout

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

44. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

45. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

46. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

2.3627x3

47.	Drive End Bearing Shaft Fit Condition			**(P) Pass**
48.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.1658x2 ***2.1660***			
49.	Opposite Drive End Bearing Shaft Fit Condition			**(P) Pass**
50.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		

Mechanical Fits- Bearing Housings

51.	Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	5.1197 ***5.1195*** ***5.1189***			
52.	Drive End - Endbell Bearing Fit Condition			**(F) Fail**
53.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	4.7257 ***4.7253*** ***4.7254***			
54.	Opposite Drive End - Endbell Bearing Fit Condition			**(F) Fail**
55.	Bearing Cap Condition			
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
	Pass			
56.	End Bell Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		
57.	List Machine Work Needed Below			
	Both end bell bearing fits			
58.	Technician			**Cw**

Dynamic Balance Report

59.	Rotor Weight and Balance Grade			
	Rotor Weight	Balance Grade		
60.	Initial Balance Readings			
	Drive End	Opposite Drive End		

61. Final Balance Readings

Drive End	Opposite Drive End

62. Technician

Rewind

63. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

64. Core Hot Spot Test

Pre-Burnout	Post-Burnout

65. Post Rewind Electrical Test- Insulation Resistance

66. Post Rewind Polarization Index

67. Post Rewind Winding Resistance

1-2	1-3	2-3

68. Post Rewind Surge Test

69. Post Rewind Hi-Pot

70. Technician

Root Cause of Failure

71. Failure locations

Bearings and end bell bearing fits

72. Root cause of failure

Contamination and wear

Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair

74. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

75. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees	90 Degrees	120 Degrees

76. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees	60 Degrees	120 Degrees

77. Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

79. Shaft Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal

80. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

81.	Drive End - Endbell Bearing Fit Post Repair			P0
	0 Degrees	60 Degrees	120 Degrees	
	5.1184	**5.1185**	**5.1185**	

82.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees

83.	Bearing Cap Condition Post Repair	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap

84.	End Bell Air Seal Fits Post Repair	
	Drive End Air Seal	Opposite Drive End Air Seal

85.	End Bell Repair Sign-off

Assembly

86.	Photograph All Major Components prior to assembly
87.	Final Insulation Resistance Test
88.	Assembled Shaft Endplay
89.	Assembled Shaft Runout

90.	Test Run Voltage		
	Volts	Volts	Volts

91.	Test Run Amperage		
	Amps	Amps	Amps

92.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial

93.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial

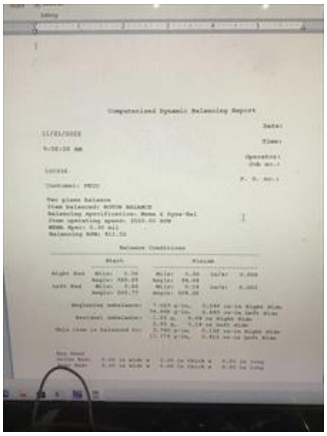
94.	Ambient Temperature - Fahrenheit

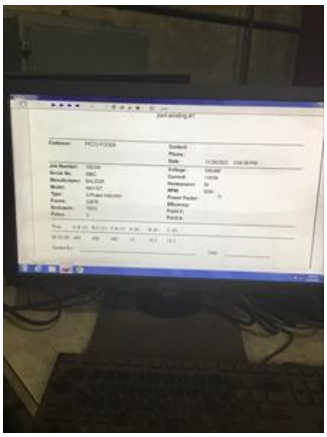
95.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

96.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

97. Final Test Run Sign-off

98. Document Final Condition with Pictures after paint P2200





99. Final Pics and QC Review **Terrence Holland**